



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D1048
Job Sheet 167303



Part No: D1048

Job Qty: 10 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/2/17

Created By: Linda Lacelle

Type: Stock ✓

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/1/17	11/1/17	0.00	0.00	Start Up Waterjet1		
100	Waterjet	10 pcs	11/1/17	11/1/17	0.00	0.27	Waterjet1		DAS
120	QC	10 pcs	11/1/17	11/1/17	0.00	0.00	QC8		38
130	Small Fab	10 pcs	11/1/17	11/1/17	0.00	0.30	Small Fab		9-89
140	Brake NC	10 pcs	11/1/17	11/1/17	0.00	0.29	Brake NC 1		SPS - DAS
150	QC	10 pcs	11/1/17	11/1/17	0.00	0.00	QC5		38
160	Powdercoat	10 pcs	11/2/17	11/2/17	0.00	0.08	Powdercoat4		BR 17/1/14
170	QC	10 pcs	11/2/17	11/2/17	0.00	0.00	QC3		38
180	Packaging	10 pcs	11/2/17	11/2/17	0.00	0.00	Packaging3		9-89
190	QC21-SA	10 Ea	11/2/17	11/2/17	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg D1048 Prog Rev: _____

Descriptions: 130 - 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

140 - Form as per dwg using DT10143

160 - START TIME: 10:30 OVEN TEMPERATURE: 320° FINISH TIME: 10:50

11-12-2017 M135418

NOV 15 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S16GA	0	164	0	0

138346.2

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches ± 0.010	0.760 0.740		
2	Clamp	2.125Inches ± 0.010	2.135 2.115		
3	Clamp	1.705Inches ± 0.010	1.715 1.695		
4	Clamp	0.375Inches ± 0.010	0.385 0.365		
5	Clamp	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

DART
AEROSPACE
S004618



Clamp

PART NO: D1048

Revision:

Operation:

Quantity:

Change No:

Start up Operation
10

Mfg Date: 11/01/17

Job No: 167303

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐			
Date : 17/11/01		Step #: 160		QTY Effective : 10		MRB (QSI042) Approval DAS 12 9-89 17/11/01	
Description Work Order Deviation				Disposition			
Change Dims to ensure proper bent shape.				Dim 1.765 now 1.755 Dim 2.125 now 2.175 Acceptable. No change to bent shape.			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				